

DAS 5412

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBEM652V3002101-M-31
Job Sheet 177790

Part No: RBEM652V3002101-M-31 Job Qty: 6 ea
Part Name: Cap
Part Weight: 0 lbs
Due Date: 7/23/18
Type: SOLD
Note: DWG RBEM652V3002101-M Rev D IPP Rev A 18.04.02 New issue DP Verify DD
Ship Via:

Status: At Planning
Job Tracking No:
Created By: Logan David
Description:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea	7/23/18	7/23/18	0.00 0.00	Start Up Machining-3		JB 18-11-08
110	Mori Seiki	6 pcs	7/23/18	7/23/18	0.00 2.00	MORI SL-154		JB 18-11-08
120	QC	6 pcs	7/23/18	7/23/18	0.00 0.00	QC2 Machining-4		JB 18-11-08
130	QC	6 pcs	7/23/18	7/23/18	0.00 0.00	QC8 Machining-4		JB 18-11-08
150	Outsource	6 pcs	7/23/18	7/23/18		GRO002-VC	10	JB 18-11-08
160	Packaging	6 pcs	7/23/18	7/23/18	0.00 0.00	Packaging2		NOV 20 2018
170	QC	6 pcs	7/23/18	7/23/18	0.00 0.00	QC6		NOV 20 2018
180	Packaging	6 pcs	7/23/18	7/23/18	0.00 0.00	Packaging3-1		NOV 20 2018
190	QC21-SA	6 Ea	7/23/18	7/23/18	0.00 0.00	QC21		NOV 20 2018

Part Op 110 - 1-Machine as per folio FC068 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 150 - -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.250	MT-4140 QT-R1.250	.3498 ft (.0583 ea)	90-Start up Operation	5017918

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.250	0	18	0

Part Specifications

Specifications could not be found.

Plex 5/17/18 3:27 PM dart.logan.david



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S126001



Part: RBEM652V3002101-M-31

Job No: 177790

Serial No/Batch: S126001

Revision: B

Inspector:

Exp Date:

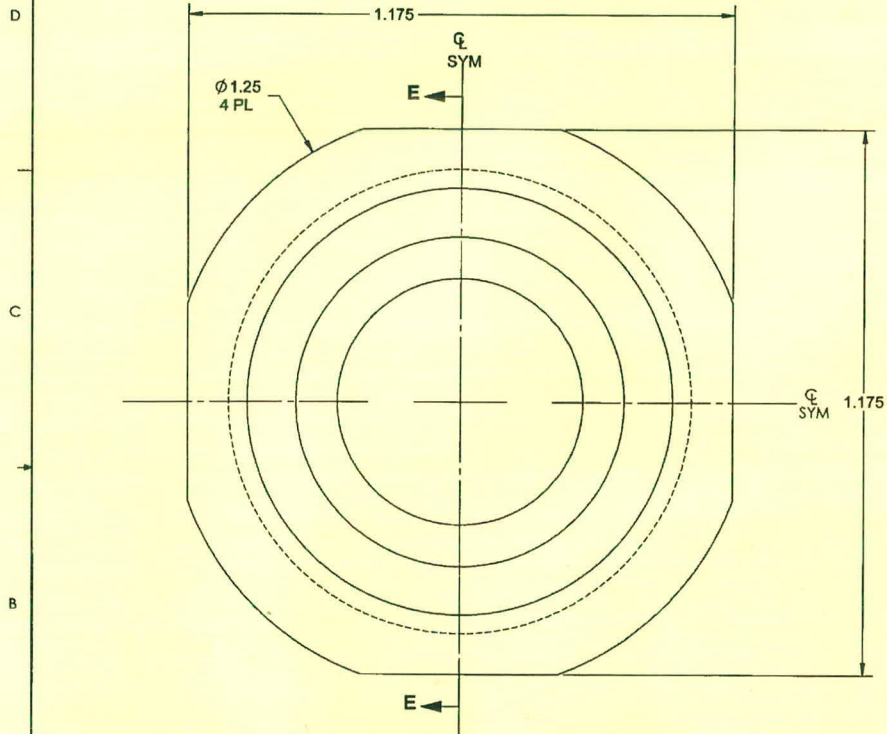
Instructions:

Date: 11/08/18

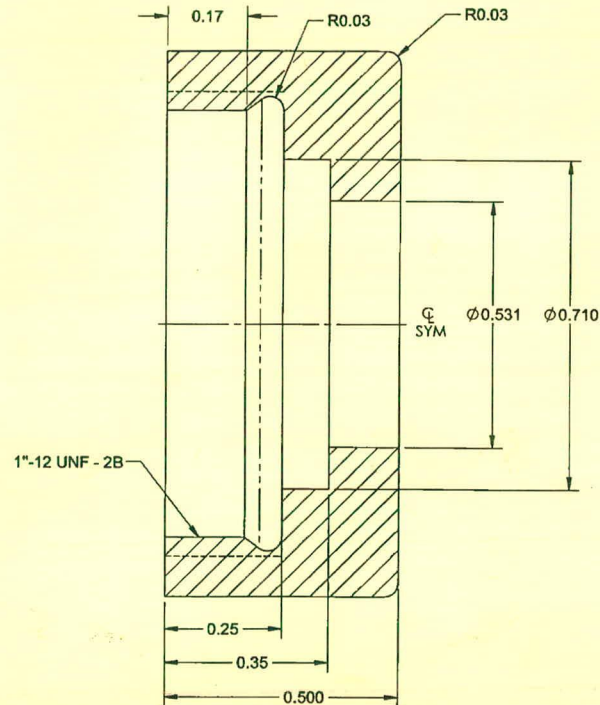
840
53
05-11

NOV 2 1958
38
05-11

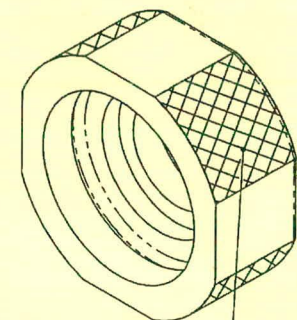
8 7 6 5 4 3 2 1



RBEM652V3002101-M-31 CAP



SECTION E-E



MEDIUM
DIAMOND
KNURL
4 PL

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = ± 0.1 " / ± 1 "
X.XX = ± 0.01 " / ± 0.5 "
X.XXX = ± 0.005 " / ± 0.1 "
X.XXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/26/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/27/2018	TOOL PART #	REV. D
MFG. APPR.	DP 03/27/2018	RBEM652V3002101-M	SHEET 9 OF 17
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE 3/28/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041692**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041692
PO Date: 11/12/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177790	RBEM652V3002101-M-31	Cap -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/16/18	12 pcs	0 pcs	12 pcs	\$5.1428571/pcs	\$61.71
Line Item Note ** Need back for morning/lunch of Nov. 15, is this possible? **											
2	183790	RBF5450-501-1-10	Handle Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/16/18	2 pcs	0 pcs	2 pcs	\$24.00/pcs	\$48.00
Line Item Note **Need Nov. 15 is this possible? **											



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PURCHASE ORDER **PO041692**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185577	RBW6205G06131-3GP	Main Rotor Pitch Control Lever Expander -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/16/18	2 pcs	0 pcs	2 pcs	\$5.1428571/pcs	\$10.29

2x

NOV 20 2018

Line Item Note **need back asap**

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

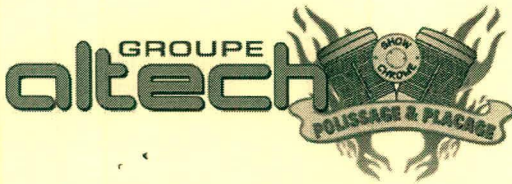
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/13/18 8:41 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014353-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014353- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Nov-2018		Jessie Boisvert		041692				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM652V3002101-M-31 Rev.	RBEM652V3002101-M-31 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	12	12	0	0	0
2	RBF5450-501-1-10 Rev.	RBF5450-501-1-10 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	2	2	0	0	0
3	RBW6205G06131 Rev.	RBW6205G06131 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	2	2	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

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8C
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